

Work Order ID 58956

Thursday, May 20, 2010 11:03:50 AM



Page 1

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket

Stop



Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-5-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005

8106661

For CL 10/06/01

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

5/30/06/01 31

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: 4113519

Exp Date: 9/12/23

5/30/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58956

Thursday, May 20, 2010 11:03:51 AM

Page 2

Item ID: D350-607-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket

Start Date: 5/20/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

~~K 607-043 558146~~

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 58956

Thursday, May 20, 2010 11:03:51 AM



Page 3

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043								
	Location:								
170		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

CL 10/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 20, 2010 11:03:56 AM

Page 1

Work Order ID: 58956

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Comments: IPP Rev:E as Per DS19318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/20/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2728-3		Manufactured	No			110	Each	0.0000	2			
Dart Logo label	5											
D350-607-241	K607-0'43	Manufactured	No			140	Each	0.0000	1			
Basket Clamp Assembly	CHC7005											
D2022-101		Manufactured	No			110	Each	237.0000	5			
Spacer												

Location

Loc Qty

Loc Code

ST504

237

45885

37

50746

100

52325

100

D2221 Manufactured No

110

Each

0.0000

1

350 Basket Base

D2258-200 Manufactured No

110

Each

6.0000

1

Placard 200lb

Location

Loc Qty

Loc Code

ST505

6

56229

6

D2332-041 Manufactured No

110

Each

14.0000

1

Lid Prop Assembly 6.69" long

Location

Loc Qty

Loc Code

ST512

14

57344

4

57645

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Parent Item Name: Heli-Utility-Basket





Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/20/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2530		Manufactured	No			110	Each	9.0000	1			
												
Handle Weldment												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506		9						
				57736		1						
				57964		2						
				58428		6						
D2535		Manufactured	No			110	Each	142.0000	2			
												
Spring												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		142						
				56355		42						
				58331		100						
D2537		Manufactured	No			110	Each	57.0000	2			
												
Bushing												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		57						
				57722		17						
				58429		40						
D2931		Manufactured	No			110	Each	862.0000	2			
												
Bumper												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		862						
				46064		862						

Thursday, May 20, 2010 11:03:56 AM

Shop Packet Print

Page 2

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 per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2989-041		Manufactured	No			110	Each	0.0000	1			
						B58958	(12)				5/20/06/01	
Basket Lid Assembly												
D2989-043		Manufactured	No			110	Each	0.0000	1			
						B58959	(10)				5/20/06/01	
Basket Lid Assembly												
AN3-16A		Purchased	No			110	Each	65.0000	2			
											5/20/06/01	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST352	65					
						113845	45					
						114523	20					
AN4-13A		Purchased	No			110	Each	119.0000	2			
											5/20/06/01	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST351	119					
						114523	119					
AN4-22A		Purchased	No			110	Each	228.0000	7			
											5/20/06/01	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST359	228					
						111965	128					
						114523	100					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Parent Item Name: Heli-Utility-Basket






Start Date: 5/20/2010

Required Date: 5/31/2010

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status																		
AN5-17A		Purchased	No			110	Each	151.0000	4																					
																														
Bolt																														
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST323</td><td>46</td><td></td></tr><tr><td>114324</td><td>46</td><td>4</td></tr><tr><td>ST339</td><td>105</td><td></td></tr><tr><td>113538</td><td>5</td><td></td></tr><tr><td>114330</td><td>100</td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST323	46		114324	46	4	ST339	105		113538	5		114330	100	
Location	Loc Qty	Loc Code																												
ST323	46																													
114324	46	4																												
ST339	105																													
113538	5																													
114330	100																													
MS20600-AD4W37	Purchased	No				110	Each	1,789.000	2																					
																														
Cherry Rivets																														
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Location	Loc Qty	Loc Code																												
ST321	1789																													
106375	3																													
107939	822																													
111636	964	2																												
AN960JD416	Purchased	No				110	Each	0.0000	14																					
																														
Washer QSI 017 NAS 114900463 J 1 M114576 (14X)																														
AN960JD416L	Purchased	No				110	Each	413.0000	2																					
																														
Washer QSI 017 NAS 114900416 J 1 M13910 (2X)																														
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST346</td><td>413</td><td></td></tr><tr><td>110153</td><td>413</td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST346	413		110153	413										
Location	Loc Qty	Loc Code																												
ST346	413																													
110153	413																													
AN960JD516	Purchased	No				110	Each	0.0000	4																					
																														
Washer QSI 017 NAS 114900563 J 1 M113706 (4X)																														

Thursday, May 20, 2010 11:03:56 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Comments: IPP Rev:E as Per DS19318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
AN960JD8		Purchased	No			110	Each	0.0000	2			
Washer												
NAS1515H4		Purchased	No			110	Each	151.0000	2			
Washer												
<div> <div>Location</div> <div>ST277</div> <div>111294</div> <div>111525</div> </div> <div> <div>Loc Qty</div> <div>151</div> <div>53</div> <div>98</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												
AN970-4		Purchased	No			110	Each	121.0000	4			
Washer												
<div> <div>Location</div> <div>ST349</div> <div>112991</div> </div> <div> <div>Loc Qty</div> <div>121</div> <div>121</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
MS21042L3		Purchased	No			110	Each	1,862.000	2			
Nut												
<div> <div>Location</div> <div>ST300</div> <div>113537</div> <div>113644</div> <div>114523</div> <div>114718</div> </div> <div> <div>Loc Qty</div> <div>1862</div> <div>20</div> <div>342</div> <div>1000</div> <div>500</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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 per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
MS21042L4		Purchased	No			110	Each	2,705.000	9			
Nut												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST139				2				
				111827				2				
				ST300				2703				
				113422				80				
				114523				1615				
				114718				1000				
				9063				8				
MS21042L5		Purchased	No			110	Each	532.0000	4			
Nut												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST300				532				
				113523				26				
				113537				3				
				114108				3				
				114437				100				
				114449				400				

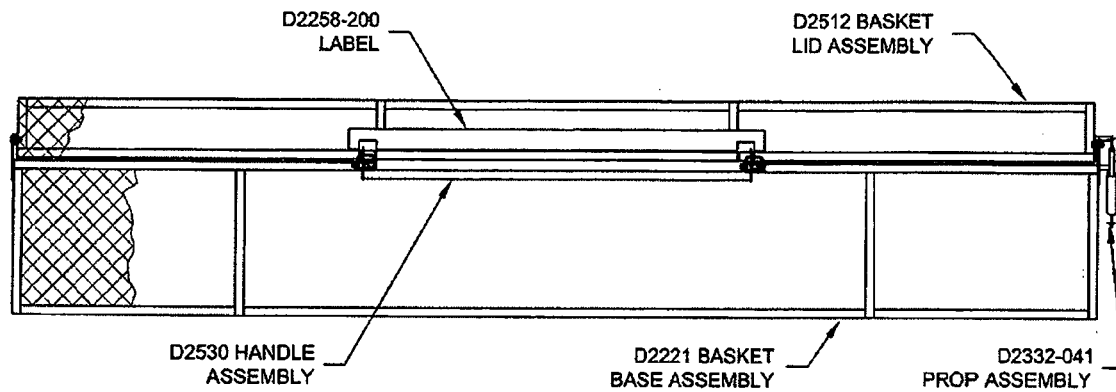
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

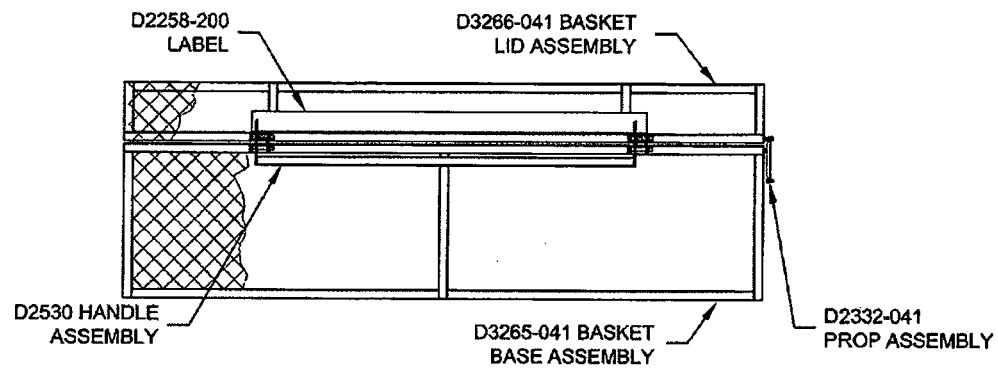
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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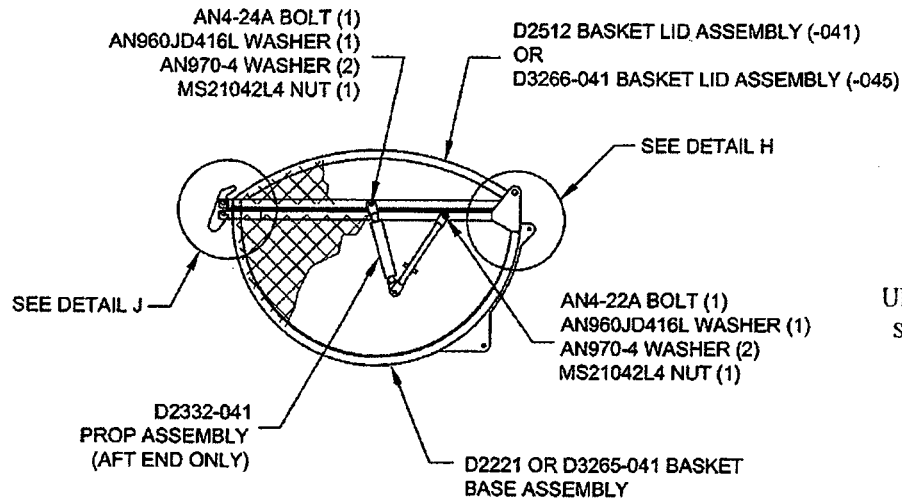
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58954

2105-20

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Revision: **A**
Date: 10.03.10

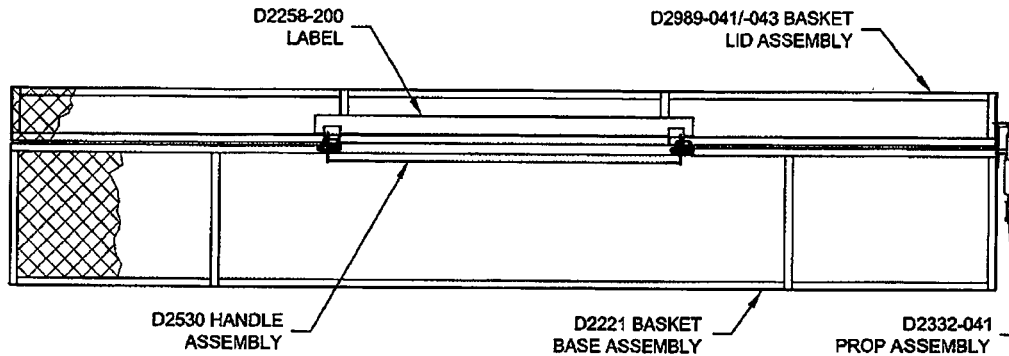
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

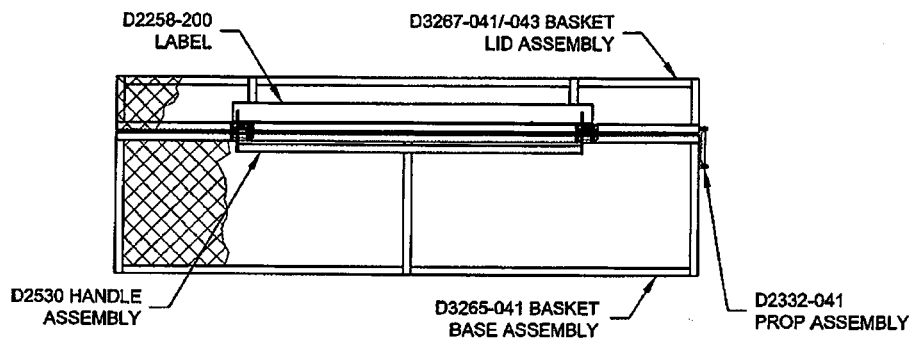
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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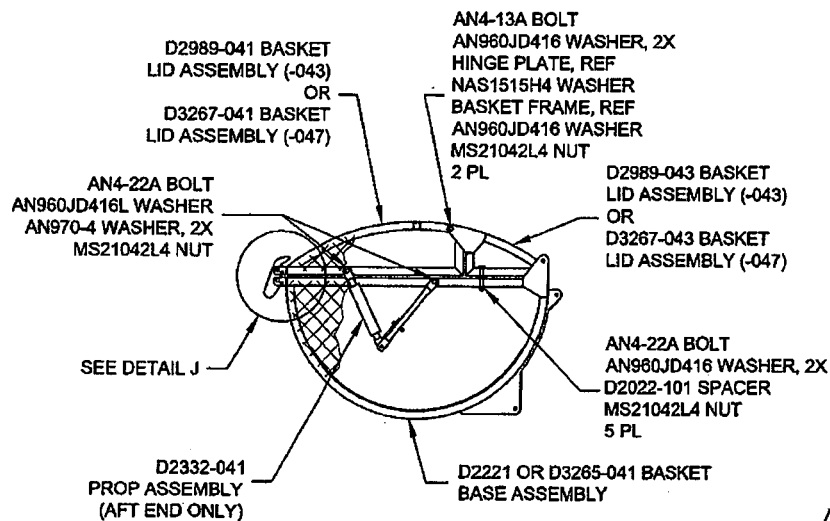
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6– Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

Wb 58254

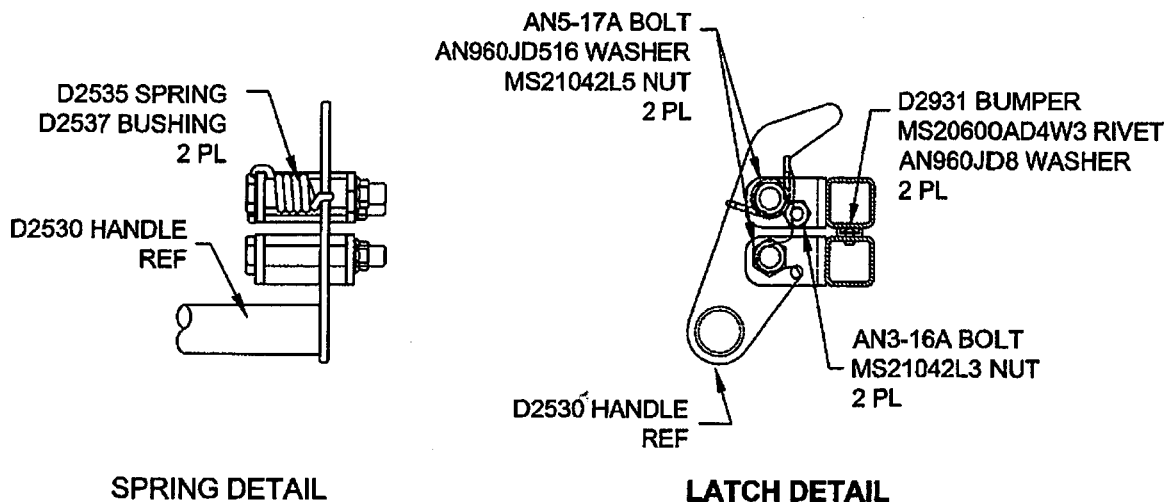
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

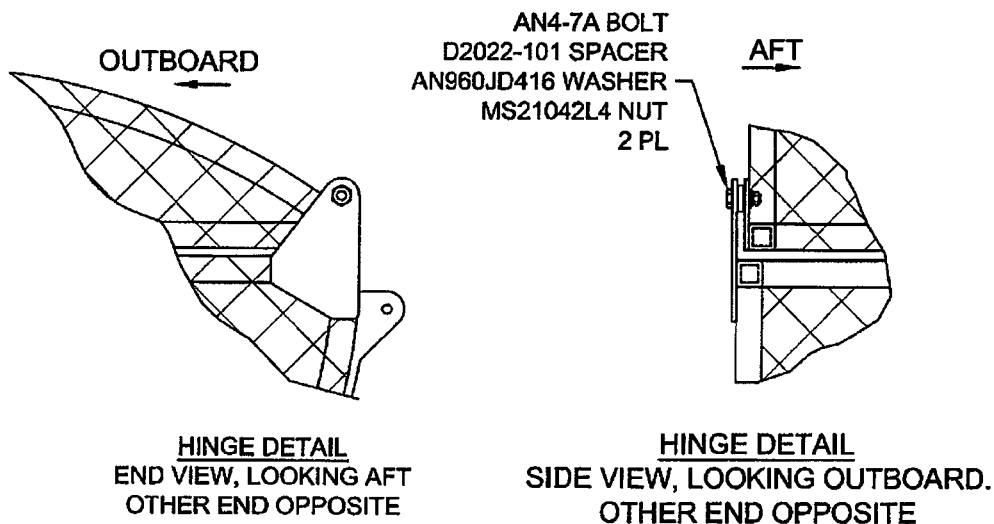
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**DETAIL J:
HANDLE WELDMENT**



**DETAIL H:
HINGE**

w/o 58954

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries